

Date: Friday, 02/05/2008 10:47:49 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARING
Job Number	: 38997		
Estimate Number	: 10091		
P.O. Number	:	Part Number	: D31835
This Issue	: 02/05/2008 S.O. No. :	Drawing Number	: D3183 REV. C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : PURCHASED PARTS	Drawing Revision	: C1
Previous Run	: 38138	Material	:
Written By	:	Due Date	: 10/05/2008 Qty: 40 Um: Each
Checked & Approved By	: <u>JUL 08.5.02</u>		
Comment	: Est: A 03.03.27 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 6285C208105102 (40)

Bearing as per Dwg D3183

Single row, deep groove, Conrad type, shielded

Possible Supplier: NSK P/N 6800ZZ

Certificate of conformity note is required

2.0	6800ZZ	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

BEARING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 75867540xse

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 02/05/2008 10:47:49 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 38997

Part Number: D31835

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/06 *JA*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

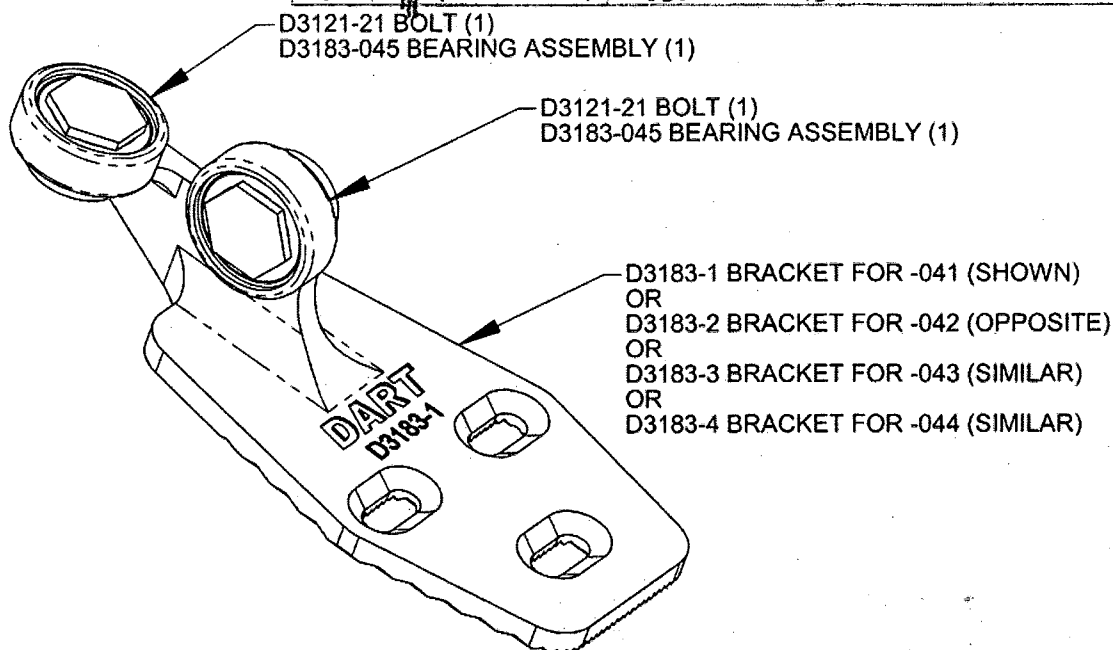
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

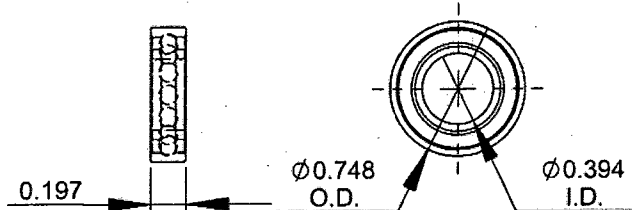


DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A.	03.01.24	NEW ISSUE	
B.	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C.	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
C1	04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01



D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



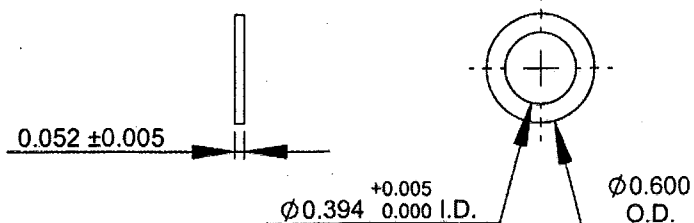
D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38497

D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES



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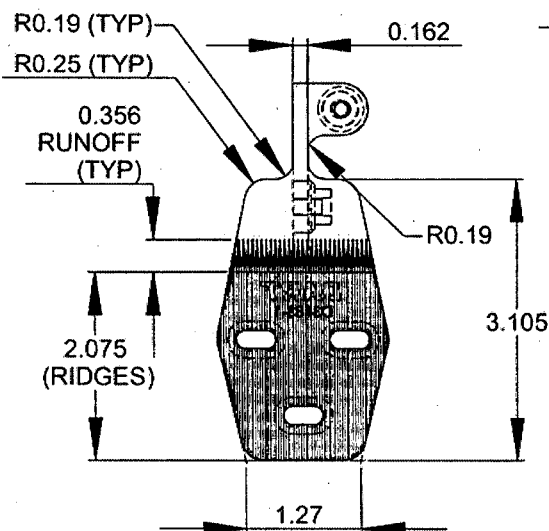
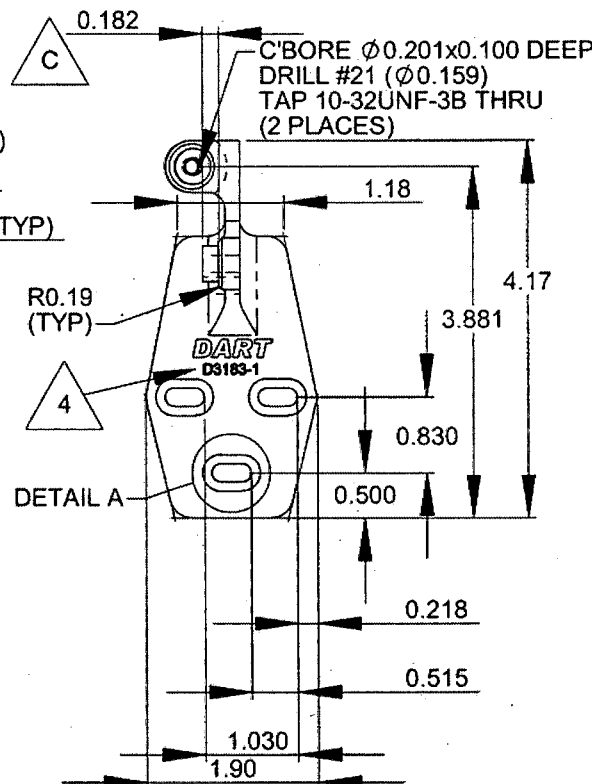
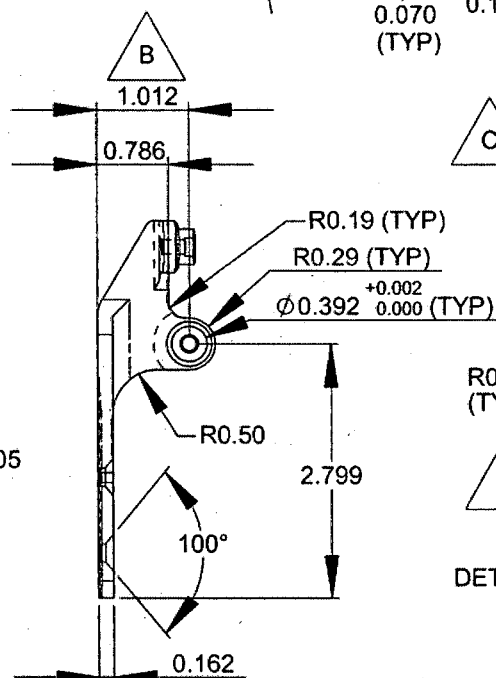
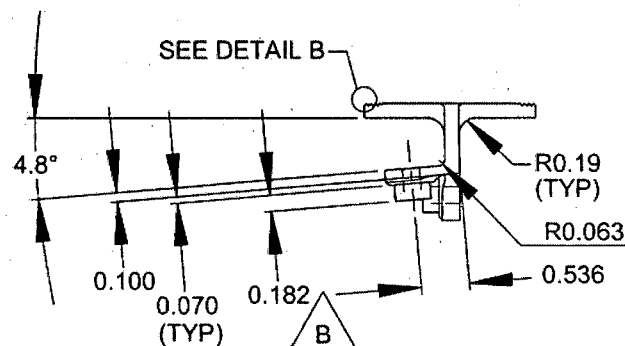
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CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 2 OF 4
DATE		TITLE	SCALE
04.02.17		BRACKET ASSEMBLY	1:2

RELEASED
04-03-01



**D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE**

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 38997

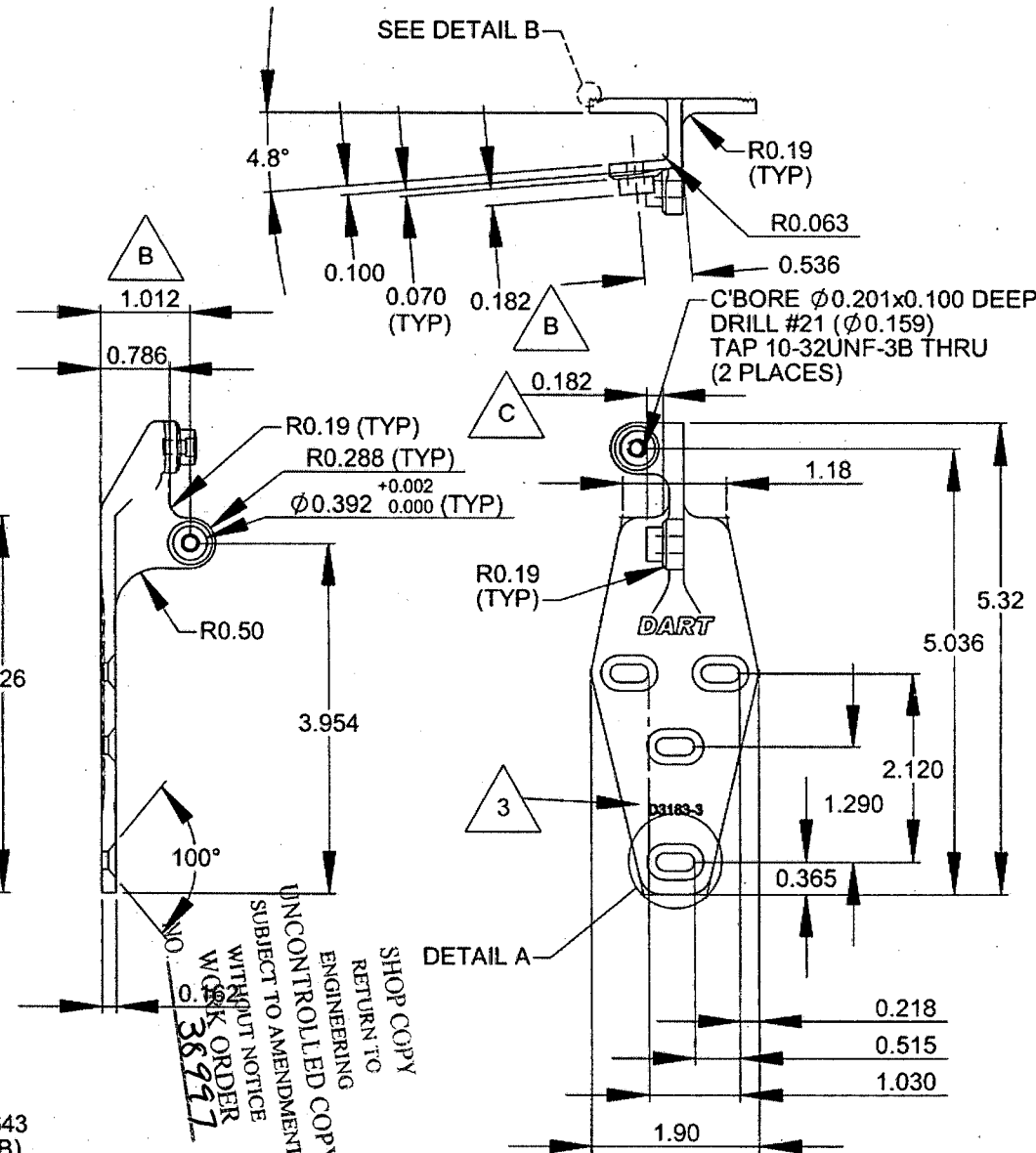
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ISSUED
04.02.17

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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 3 OF 4
TITLE	SCALE	1:2
BRACKET ASSEMBLY		



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
36997

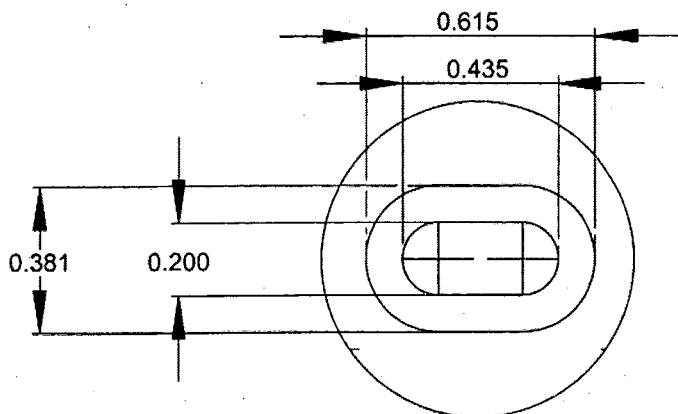
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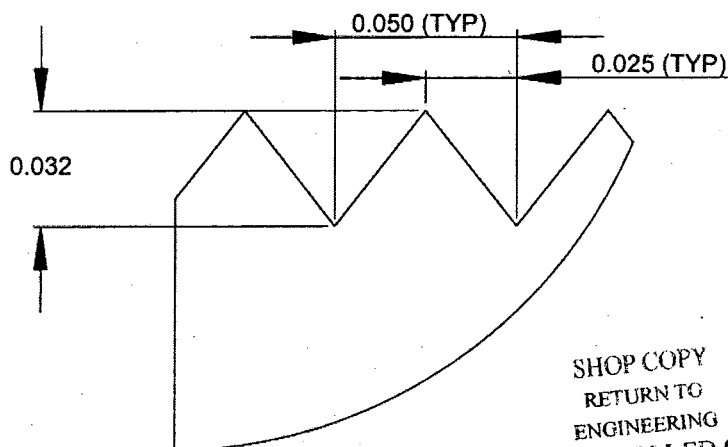


DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SCALE 1:1	



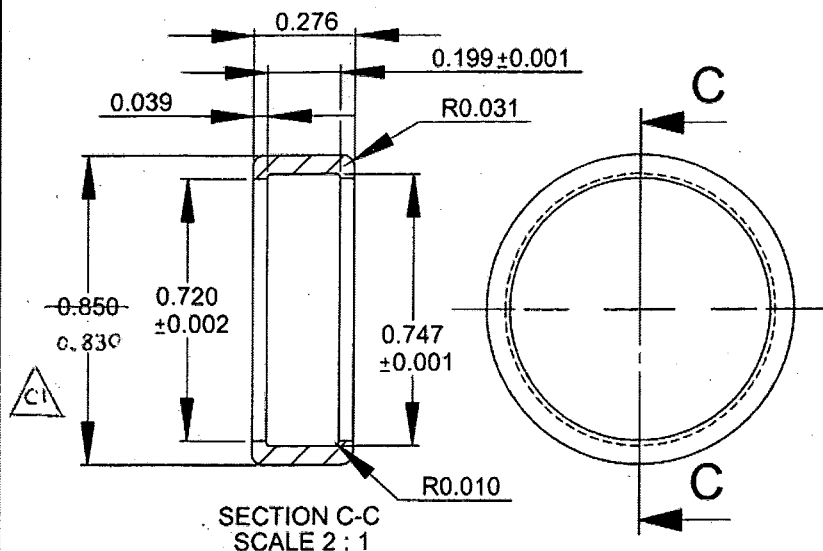
DETAIL A (2 : 1)

RELEASED
04.03.01 #



DETAIL B (20 : 1)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38997



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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GENERAL BEARING SERVICE Inc.

1304213

cie
GENERAL BEARING SERVICE
 www.gbs.ca inc.

386 MAIN ST E, HAWKESBURY, ONTARIO K6A 1A8 (613) 632-9914

GST # R101979094

ORDER DATE: MAY 5, 2008

SOLD TO: DART AEROSPACE LTD.
 1270, ABERDEEN STREET
 HAWKESBURY, ON. K6A-1K7

SALE MADE BY: DR
 SHIP VIA:

CUSTOMER ORDER #: 00006285

PST LICENCE: 6122-5207

PRODUCT	DESCRIPTION	SOLD	SHIP	PRICE	EXTENSION
6800-ZZ	BALL BEARING	40	40	4.89	195.60
6900-ZZ	BALL BEARING	200	200	4.89	978.00
				G.S.T.	58.68

PACKING SLIP NO: 593070-0

RECEIVED BY: Robert Girard

Comments: AS PER DWG D3121 REV. E
 SKF P/N: 61900-ZZ OR KML P/N: 6900-ZZ
 B38995

1304220

THIS FORM MUST BE COMPLETED IN ORDER TO BE VALID. E & O.E.
 DOIT ETRE IMPRIME PAR ORDINATEUR POUR ETRE VALIDE E & O.E.